

ABSTRACT

A composite laminate 1 having shrink-prevention ceramic green sheets 5 arranged on both of the main surfaces of an unfired ceramic laminate and being substantially incapable of being sintered at the firing temperature of the unfired ceramic laminate 4 is fired at a temperature which is higher than the sintering temperature of the unfired ceramic laminate, and is lower than the sintering temperature of the shrink-prevention ceramic green sheet. Thereafter, the shrink-prevention ceramic green sheets 5 are removed in a first removing step of spraying water and compressed gas against the shrink-prevention ceramic green sheets so that a part thereof not reacted with a glass component of the unfired ceramic laminate 4, and in a second removing step of ceramic powder, spraying water, and compressed air, so that a residual material not removed in the first removing step is removed, and in a third removing step of supersonic-cleaning the ceramic multi-layer substrate subjected to the first and second steps.